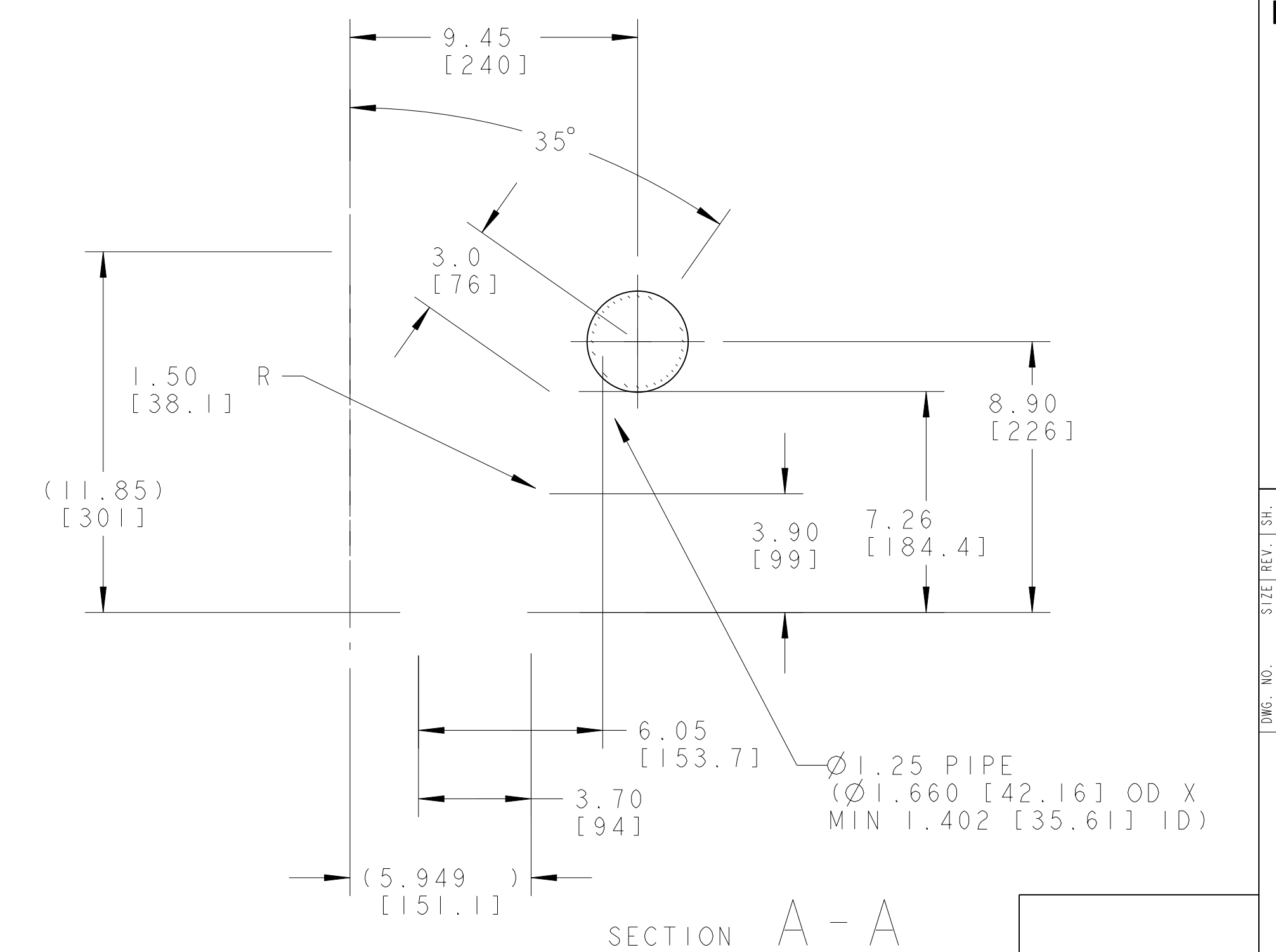
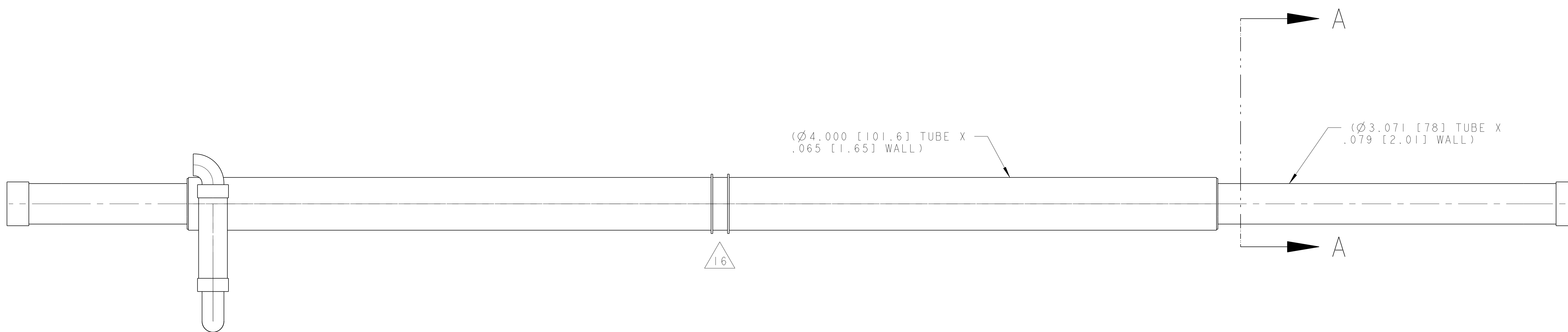
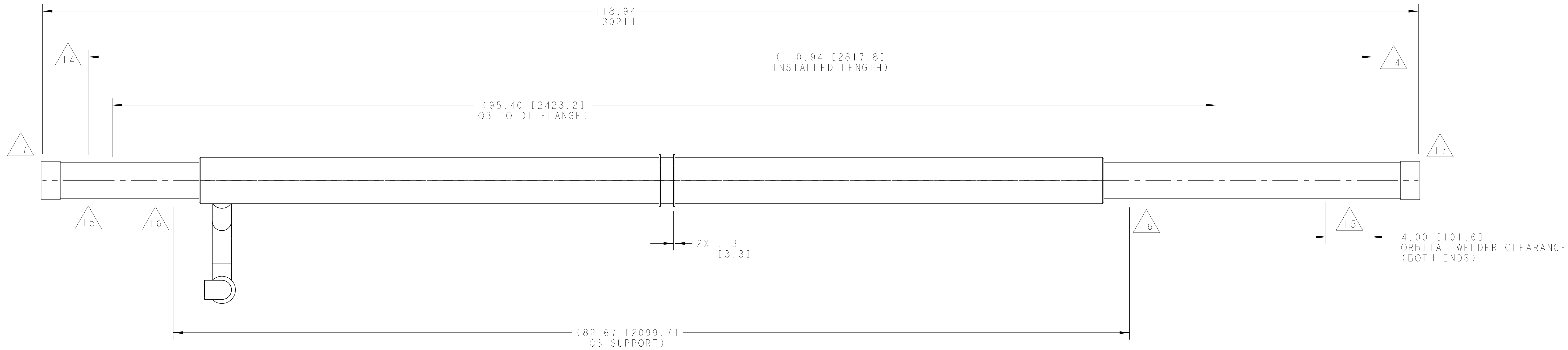
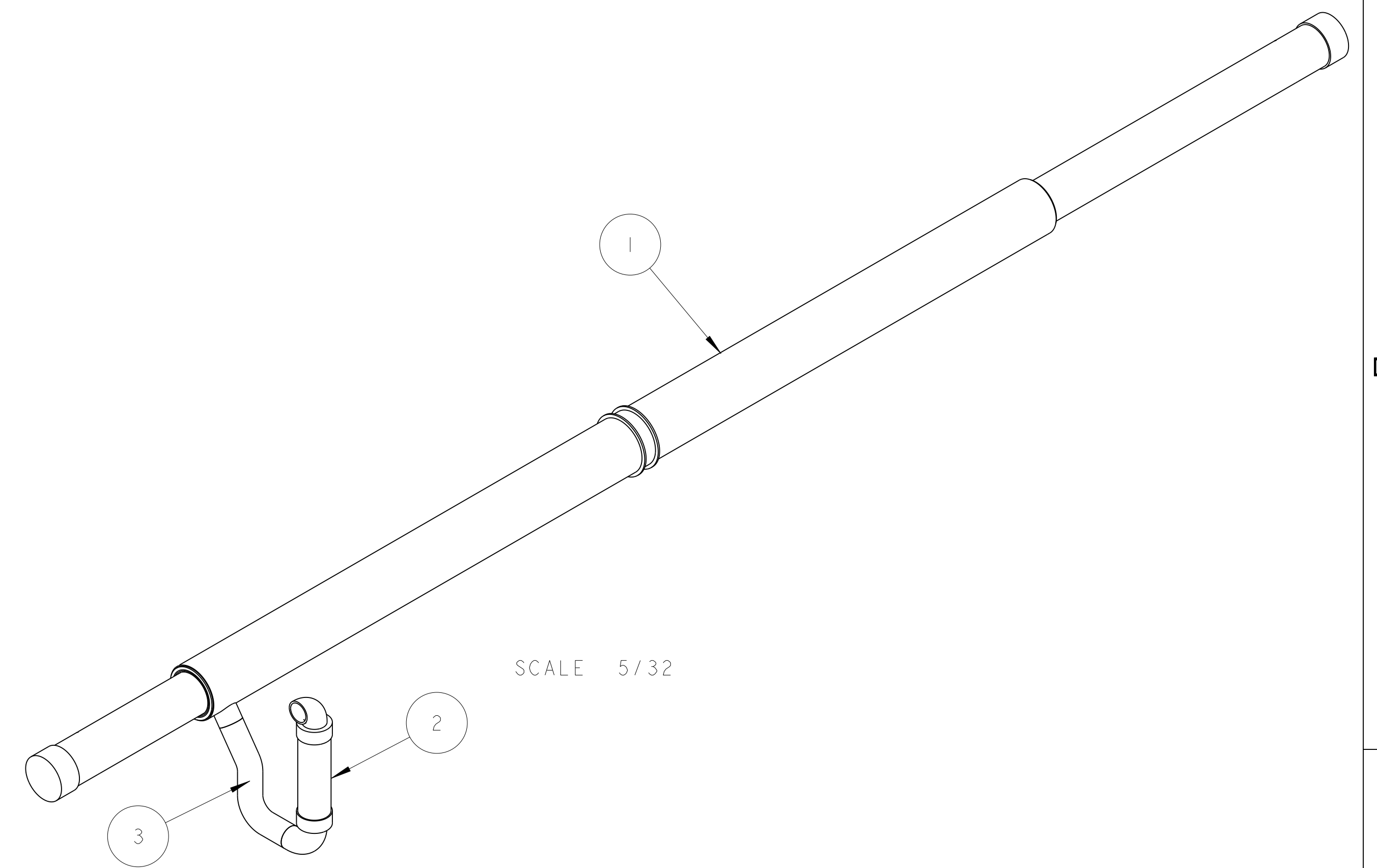



1. THIS IS A CRYOGENIC VACUUM COMPONENT.
2. WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
3. CLEANING PROCEDURE : PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
4. PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS:  
PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
5. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982.  
UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
6. USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS,  
OR COOLANTS ARE STRICTLY PROHIBITED.
7. USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER  
IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES  
ONLY.
8. VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO  
LBNL APPROVAL.
9. FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.

4. VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
11. REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
12. TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN  $\pm .010$ .
13. PERFORM ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.
14. A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL, TO AN ACCURACY OF  $\pm 0.063"$ .
15. PROVIDE A MINIMUM LENGTH OF 4.0" OF STRAIGHT, SMOOTH PIPE ON THE INDICATED SIDE OF THE INSTALLED LENGTH MARK FOR PIPE WELDING DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY.
16. PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 0.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
17. CAP BOTH ENDS OF PIPE AFTER ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.



3	-	1	NIPPLE, TUBE, PER ASTM A269	SS 304L
4	-	1	BRIDLED FLEX HOSE, 1 1/2" - 10 X 6.1" LL	SS 300 SERIES
5	1	281555	V PIPE & JACKET ASSEMBLY	
ITEM PART NO REQD			DESCRIPTION	MATERIAL
SHOP ORDERS			<b>ERNEST ORLANDO LAWRENCE</b> <b>BERKELEY NATIONAL LABORATORY</b> UNIVERSITY OF CALIFORNIA - BERKELEY 	
ACCT NO	DATE	DATE	DATE	DATE
01	1/30	1/30	1/30	1/30
SUPPORT			LHC IR FEEDBOX	
EQUIPMENT			CRYOGENICS	
METHOD			PIPE, V & JACKET	
TAG				
NUMBER				
PROJECT N/A				
DATE 15-Dec-01			SCALE: 1/4	
BY: R. LA MANTIA			SHEET 1 OF 1	
DATE 4-02-02			DOW: _____	
BY: Jon Zosnick			APPROVED BY: _____	
DATE 4-02-02			2512066	
BY: Jon Zosnick			A	